

Date: Tuesday, 19/08/2008 4:07:27 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT PLATE  
 Job Number : 41512 -1  
 Estimate Number : 13385  
 P.O. Number :  
 This Issue : 19/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 40244  
 Part Number : PB674300171  
 Drawing Number : B6743001 P.9/26  
 Project Number : N/A  
 Drawing Revision : B1  
 Material :  
 Due Date : 18/09/2008 Qty: 30 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.8.20  
 Comment : Est Rev:A 08-06-19 new issue DD verified by:ec  
 Est Rev:B 08-06-27 procedure chg DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.8594 sf(s)/Unit Total : 25.7828 sf(s)

6061-T6 .090 Sheet

batch: 109184 IB 8-9-9

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001-159

Dwg Rev: B1

Prog Rev: B1

\*\*\*\*grain direction along 5.750" \*\*\*\*

2-Deburr if necessary

IB 8-9-9

IB 8-9-9

30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



POSITIVE RECALL

EFFECTIVE 08.09.09

AUTH: [Signature]

RELEASED [Signature]

DATE 08.09.10

Comment: SECOND CHECK

Scobolko (+30)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- countersink as per dwg B67-43001

08/09/11 (30)  
 08/09/15 (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-71 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/09/16  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>41512</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/15</u>	<u>5</u>	<u>1 piece <del>was</del> was out of tolerance RC poor drawing</u>	<u>[Signature]</u>	<u>Scrap &amp; destroy No Replue</u>	<u>SB</u>	<u>[Signature]</u> <u>08/09/16</u>	<u>[Signature]</u>	<u>08/09/16</u>

NOTE: Date & initial all entries



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Drawing Name: SUPPORT PLATE

Job Number: 41512

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*508/02/16 229* *caution*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1- weld as per dwg B67-43001

*08.09.22 8*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-grind weld flush

*08.09.24 8*

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*08.09.24* *BE* *(XB)*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*508/03/24 (XB)*

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*08/09/24*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*[Large handwritten X mark across steps 11.0 and 12.0]*

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 180.0000 Each(s)  
Nutplate

*M109068*

*08/09/24*

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 360.0000 Each(s)  
RIVET

*M105978*

*08/09/24*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Job Number: 41512

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-install nut plates as per dwg B67-43001

08/09/24 (8)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/24 (8E)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 246

8/9/24

(8x)

50

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26 (8)

Job Completion



MF 08-09-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

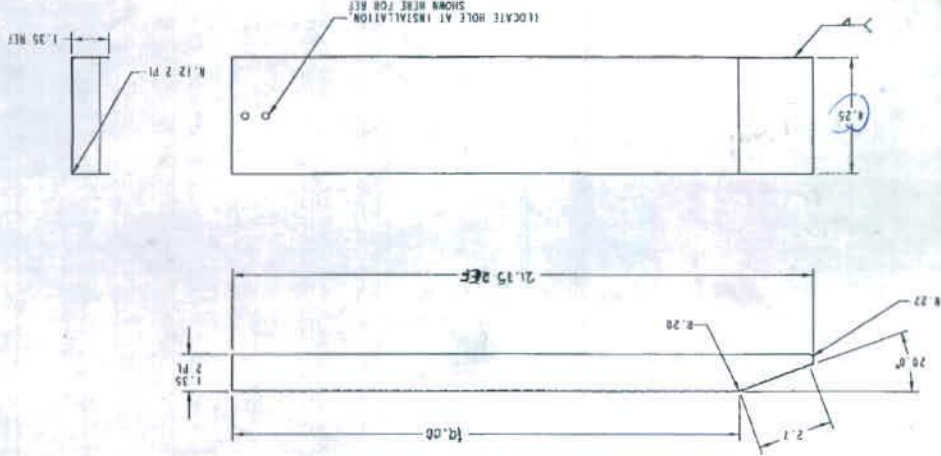
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

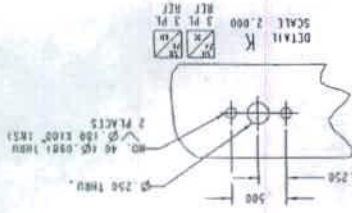
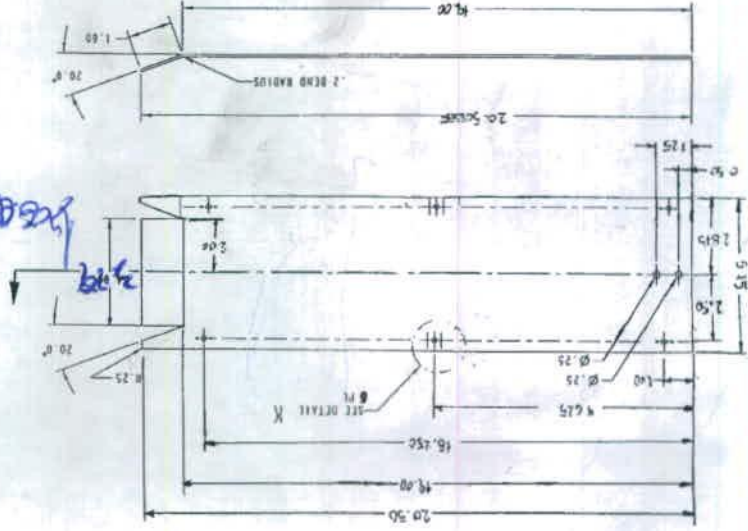
ORIGINAL

PREMIER AVIATION, INC.  
1000 American Parkway, Concord, MA 01735  
TEL: 603-255-1111 FAX: 603-255-1112  
D050V8 B67-A3001

② -73 20 DEGREE COVER PLATE  
MATERIAL: 0.02 IN. 6061-T6, 00-A-250/11  
SCALE: 0.500



① -159 SUPPORT PLATE  
MATERIAL: 0.030 IN. 6061-T6, 00-A-250/11  
SCALE: 0.500



RELEASED  
#4412

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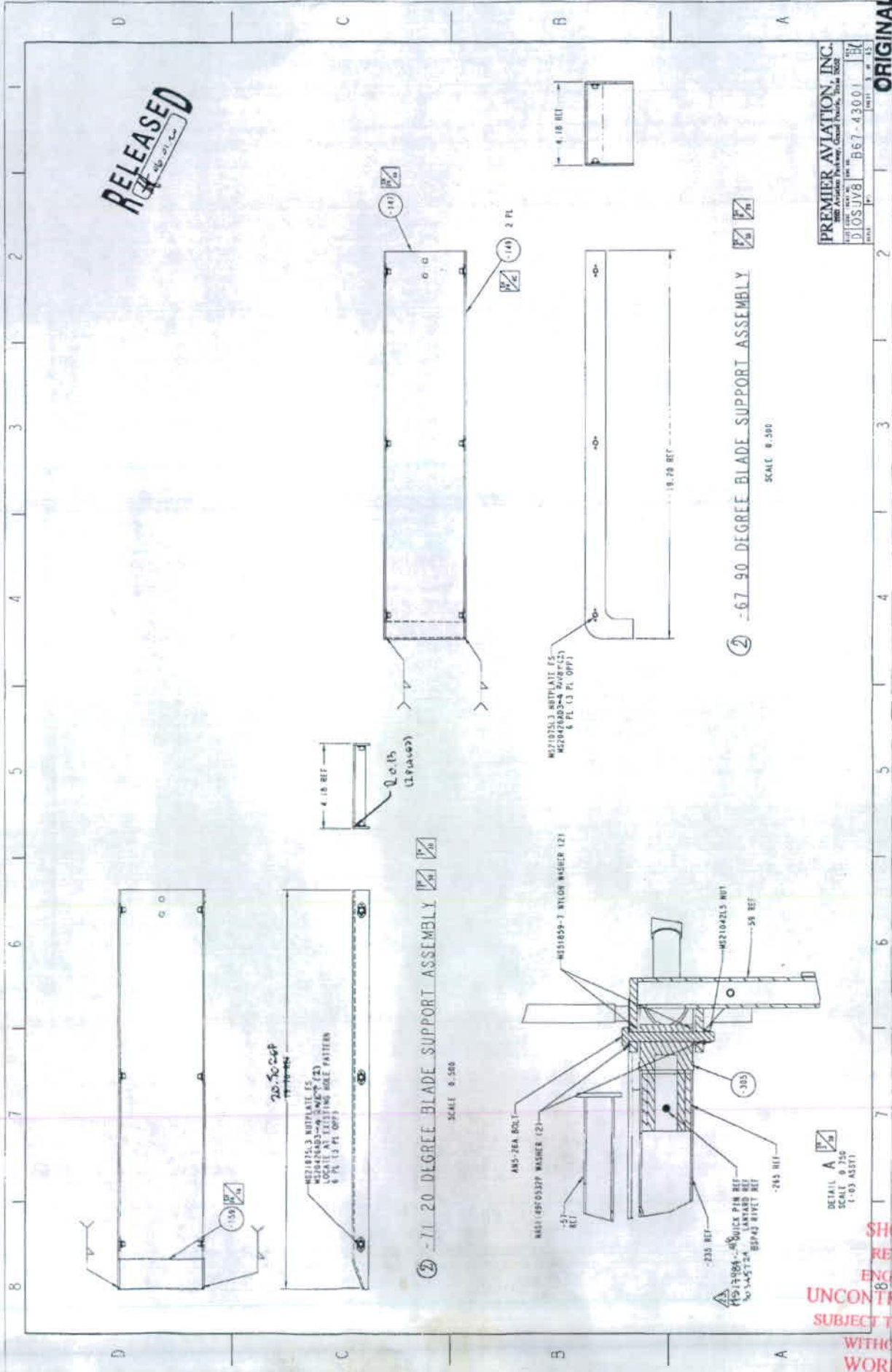
WITHOUT NOTICE  
WORK ORDER  
NO. 41512







RELEASED



PREMIER AVIATION, INC.  
1000 Airport Blvd., Suite 1000  
Birmingham, Alabama 35202  
TEL: (205) 944-1111  
FAX: (205) 944-1112  
DLOSJV8 B67-43001

ORIGINAL

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